

Work Order ID 94293

94293

Wednesday, December 05, 2012 1:34:11 PM

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Ships Thurs
ARM

Item ID: D3136-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Window Assembly
 Start Date: 12/5/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 12/6/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-12-05 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	Rev E								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 1/8" Plexiglas G Dwg Rev: F
 Prog Rev: E B1212-6 Pto
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00 B1212-6
 Quality Control
 120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00 x4 DAS
 Quality Control 07
 12/12/06

NCR: ☒ Yes ☐ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *[Signature]*

Date: 12/12/13

QA Closed: *[Signature]*

Date: 1/1

Work Order: <u>94293</u> Part No. <u>D3136-043</u> NCR No. <u>12-2125</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input checked="" type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/> Equip/Tooling <input checked="" type="checkbox"/> Operator <input checked="" type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	12/12/13	#100 121	6 x1 <u>(7)</u>	Found at inspection that operator has ground down on step 2 window a too aggressively & Qty ALL have blow outs from the water jet.	DAS 16 0-89 051012 12/12/13	SCRAP + Destroy and Reshape at x6. B 123704 34.75 243.25	12-12-13 <i>[Signature]</i>	12/12/13 <i>[Signature]</i>	DAS 16 0-89 051012 12/12/13			
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other <i>operator error in Subcontract material</i>			

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Item ID: D3136-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Window Assembly

Start Date: 12/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/6/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

1-Deburr if necessary

2-Thermoform as per Dwg D3136 and Folio FTA002
Dwg Rev. EFolio Rev. C.3- Engrave Part # and Batch # , and affix labels
(D3136-3)

0.00

0.00

0.00

0.00

X6DAS
37
12/12/06X6BB
12/12/06

140

140

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Water sand and buff to remove scratches as required

0.00

0.00

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Item ID: D3136-043 Accept *N900040100* Setup Start *NS1*
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 Required Date: 12/6/2012 Req'd Qty: 6.00 *6* Customer:
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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
150									
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control	Inspect edge and window deformation, wrap in plastic								
180	Identify as per dwg & Stock Location	0.00							
180									
Packaging	Memo	0.00							
Packaging									

X6 12/12/12
 45 710
 45 12-12-6

NCR: Yes / No**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: <u>94293</u> Part No. <u>D3136-043</u> NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input checked="" type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input checked="" type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
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Doc/Data <input type="checkbox"/> Equip/Tooling <input checked="" type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	<u>12/12/06</u>	<u>#1</u>	<u>150</u>	window scrap due to having burrs on out side of window.	DAS 16 9-89 AS 7042 12/12/06	Scrap + Destroy off #1 w/o Reske.	<u>B</u> 12/12/06	DAS 07 2-89	AS 7042 12/12/06																		
FAULT CATEGORY																											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other																		

Work Order ID 94293***94293***

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Item ID: D3136-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window Assembly

Start Date: 12/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/6/2012 Req'd Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/12/10

MF

12-12-05

Picklist Print

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T

Work Order ID: 94293
Parent Item: D3136-043
Parent Item Name: Window Assembly

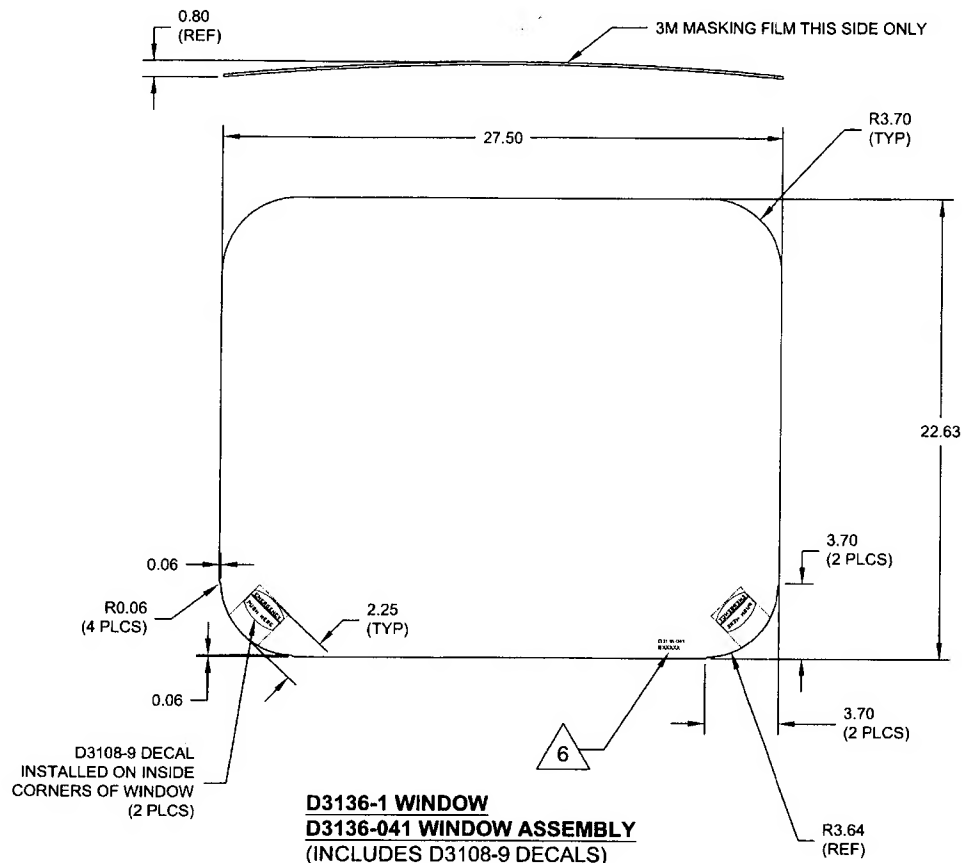
Start Date: 12/5/2012 Required Date: 12/6/2012
Start Qty: 6.00 Required Qty: 6.00

Comments: IPP Rev:A04.02.04New issueKJ/DS
IPP Rev.B 07.05.29 Thermoform in-house DL
IPP rev C 07.09.28 Rev E dwg EC verified by:DD IPP Rev:D 10.06.24 added note in qc5
seq 170 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3108-9 Decal		Manufactured	No			100	Each	538.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST026		538							
				34554		38				12			
				46546		500							
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			170	sf	523.8935	3.9	23.4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT019		523.8935							
				110633		3							
				117324		0.2467							
				117431		10.7967							
				119591		15.16							
				121850		44.5456							
				123704		106.4				123764			
				123895		343.7445							

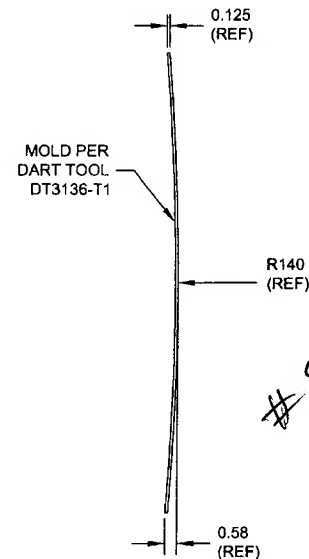
DL
12/12/00

1812-12-6



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS



RELEASED
07.09.22

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3136
TITLE WINDOW ASSEMBLY
SCALE 1:6
REV. E
SHEET 1 OF 2

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